

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-020705**Date Inspected:** 23-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Yang Bai Qiung**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG, Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Dennis Combs, was present during the times noted above for the observations relative to the work being performed.

**Bay 13**

This QA Inspector observed the following work in progress for Bay 13.

ZPMC was using the Flux Cored Arc Welding (FCAW) process.

ZPMC QC is identified as Wang Xi

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Grillage

PCMK: SA7038-001

Weld Number: 015, 021

Welder: 067079

WPS-B-T-2231-ESAB

**Bay 14**

This QA Inspector observed the following work in progress for Bay 14.

ZPMC was using the Flux Cored Arc Welding (FCAW), and Shielded Metal Arc Welding (SMAW) processes.

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ZPMC QC is identified as Wang Xi

Welding variables recorded by QC appeared to comply with the approved Welding Procedure Specification (WPS).

Listed below are the locations that were identified by this QA inspector.

Component: Floor Beam

PCMK: SEG3020E

Weld Number: 044, 053

Welder: 201215

WPS-B-T-2233-ESAB

Component: I Rib

PCMK: SEG3015K

Weld Number: 283, 284

Welder: 201583

WPS-345-FCAW-1G-FCM-Repair

B-CWR2293

Component: Architectural Housing

PCMK: AH3002

Weld Number: 007

Welder: 048696

WPS-B-T-2231-ESAB

Blast Bay 4

This Caltrans QA Inspector along with two other Caltrans QA inspectors performed a pre-blast visual inspection of the interior, and exterior surfaces, East Tower Lift 5 subassembly grillage, 146~151 meter mark to the bottom surface of the saddle grillage. Surface defects and base metal surface irregularities that required grinding were marked up with colored chalk, and weld defects that require welding were taped with gray masking tape for repair after the coating has been applied. ZPMC QC and ABF inspection personnel were present during the inspection and informed of QA findings.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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## Summary of Conversations:

No relevant conversations.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Combs,Dennis	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley,Ken	QA Reviewer

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